

|                       |   |                  |                  |      |      |
|-----------------------|---|------------------|------------------|------|------|
| Customer              | : CU-DAR001 Dart Helicopters Services         | Drawing Name     | : HEATER BRACKET |      |      |
| Job Number            | : 35323                                       |                  |                  |      |      |
| Estimate Number       | : 12159                                       |                  |                  |      |      |
| P.O. Number           | : N/A   | Part Number      | : D2002003       |      |      |
| This Issue            | : 10/23/2007 S.O. No. : N/A                   | Drawing Number   | : D2002 REV C    |      |      |
| Prsht Rev.            | : NC  | Project Number   | : N/A            |      |      |
| First Issue           | : N/A Type : SMALL /MED FAB                   | Drawing Revision | : C              |      |      |
| Previous Run          | : 28129                                       | Material         | : N/A            |      |      |
| Written By            | : <u>[Signature]</u>                          | Due Date         | : 11/15/2007     | Qty: | 10   |
| Checked & Approved By | : <u>[Signature]</u>                          |                  |                  |      | Each |
| Comment               | : Est. B 99.05.21 Re-format, Made in house DM |                  |                  |      |      |
|                       | : Est Rev:C Now on Waterjet 06-08-14 JLM      |                  |                  |      |      |

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

1.0 M2024T3S063 2024-T3 .063 sheet

Comment: Qty.: 0.4083 sf(s)/Unit Total : 1.6334 sf(s)

2024-T3 .063 sheet

Material: 2024-T3, 0.063" Thick

Batch 102942

| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|
|-----|-----------|----------------|

Comment: FLOW WATER JET

1-Cut as per Dwg D2002-003

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0      QC8      SECOND CHECK

Comment: SECOND CHECK

50 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1

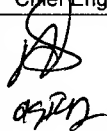

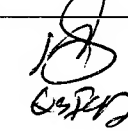
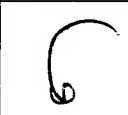
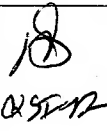
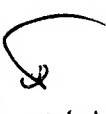
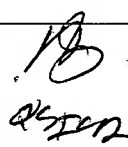
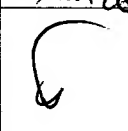
**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
Countersink holes as per Dwg D2002-003

Deburr

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/11/28  
 QA: N/C Closed: ☐ Date: \_\_\_\_\_

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)                           |   |                                 |                |   |   |   |
|----------|------|--|---|---------------------------------|----------------|---|---|---|
| DATE     | STEP | Description of NC<br>Section A                             | Corrective Action Section B   |                                 |                | Verification<br>Section C   | Approval<br>Chief Eng   | Approval<br>QC Inspector  |
|          |      |  | Initial<br>Chief Eng  | Action Description<br>Chief Eng | Sign &<br>Date |   |   |   |
| 07/11/19 | 5    | 1 piece crack<br>at the bend<br>R.C. setup (first part)    |    | Scrap &<br>destroy              | SB<br>07/11/19 | <br>07/11/26   |    | <br>07/11/26   |
| 07-11-26 | 5    | 1 piece, counter<br>sink hole too big.<br>R.C. human error |  | Scrap &<br>destroy              | MF<br>07-11-26 | <br>07/11/26 |  | <br>07/11/26 |
|          |      |  |   |                                 |                |   |   |   |

NOTE: Date & initial all entries

Date: Tuesday, 10/23/2007 3:10:29 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEATER BRACKET

Job Number: 35323

Part Number: D2002003

Job Number:



Seq. #:

Machine Or Operation:

Description :

Form as per Dwg D2002-003

SB 07/11/19

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counts  
9/11/26 (9)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M. 07/11/27

(9X)

8.0

POWDER COATING

POWDER COATING



Comment: PURCHASING

Powder Coat Black Crinkle (Ref. 4.3.5.3) as per QSI 005 4.3

m 102316

FL 07/11/27 (9)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M. 07/11/27

(9X)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5166

0

B 07/11/28

(9)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/28

(9)

Job Completion



07/11/28

**Dart Aerospace Ltd**

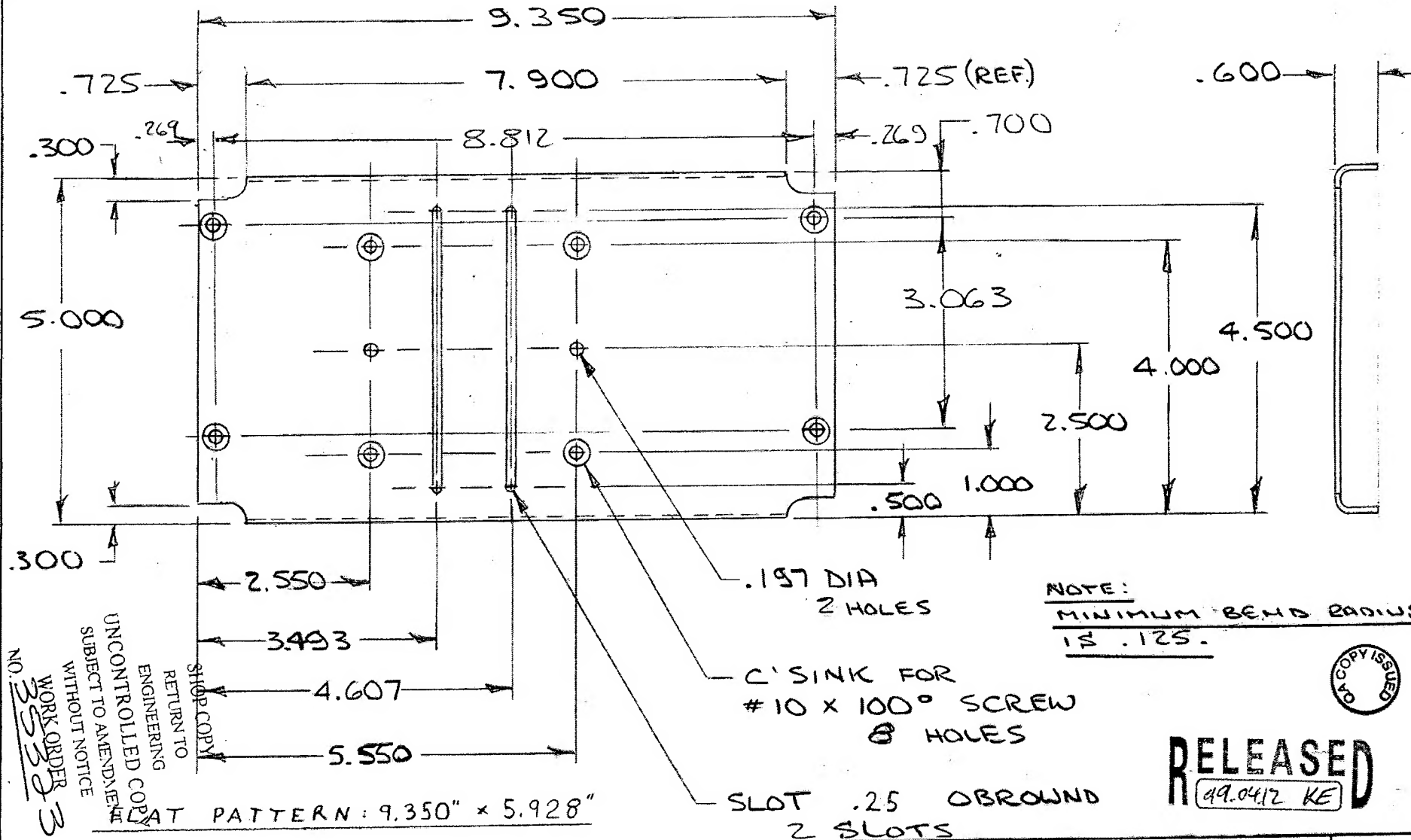
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

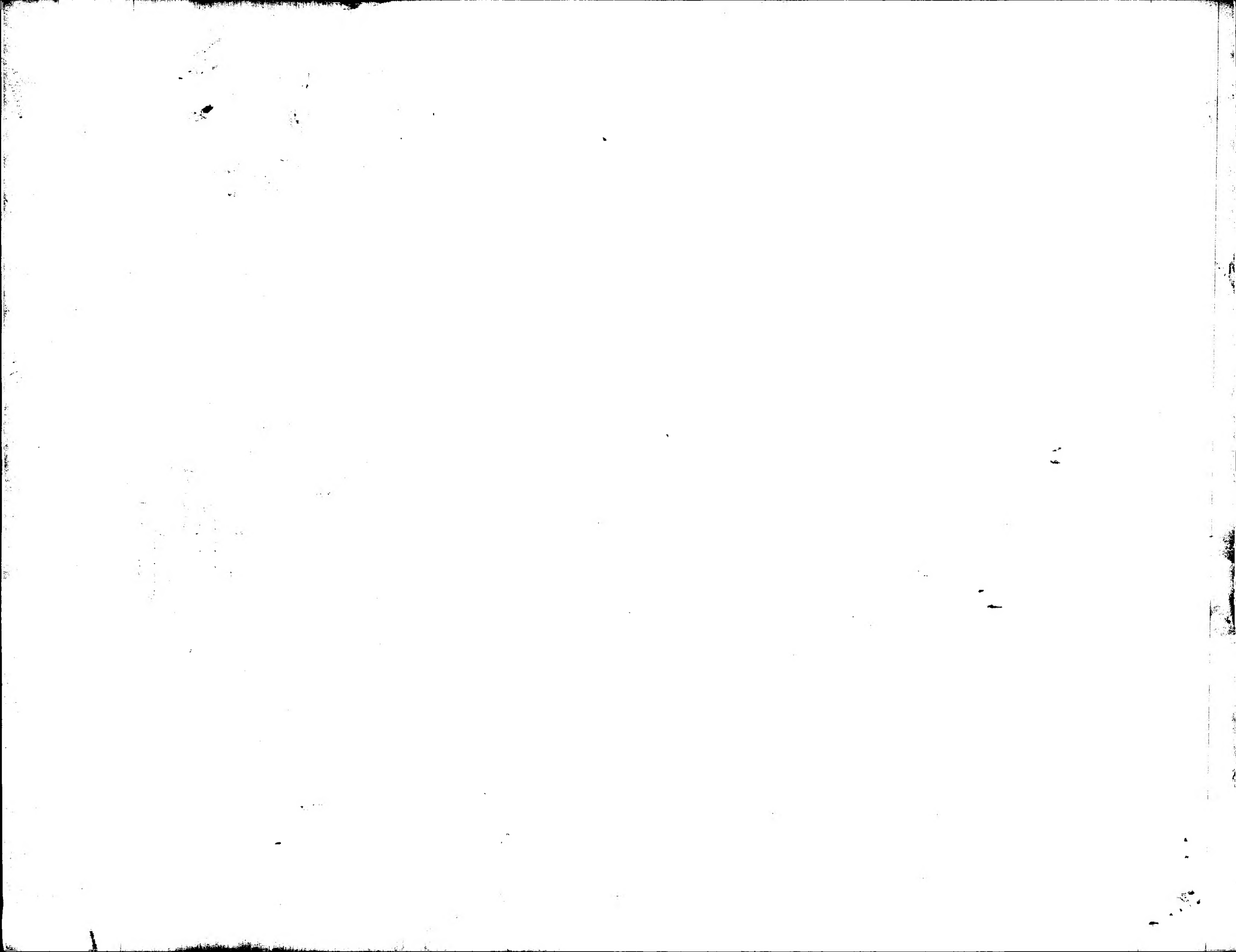


RELEASED  
49.04.12 KE

|        |       |          |   |  |  |  |
|--------|-------|----------|---|--|--|--|
| C B A  |       | REVISION | RIVET CODE SHALL BE PER NAS 623   |  | D2002-003 BRACKET 2024-T3 x .063 QQ-A-250/5    |  |
| KE     | JB    | DRAWN    | THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO. |  | PART NO. ITEM DESCRIPTION MATERIAL SPEC/VENDOR |  |
| 4/2/72 | 11/28 | APPROVED | BASIC CODE  |  | CONTRACT NO.                                   |  |
| 4/2/72 | 11/28 | APPROVED | D=DIMPLE<br>DGT=NO OF SHEETS<br>C=COUNTERSINK   |  | DRAWN<br>BRADLEY 9/19/10                       |  |
| 4/2/72 | 11/28 | APPROVED | LENGTH DASH NO.<br>W=SPOTWELD   |  | DATE<br>9/19/10                                |  |
| 4/2/72 | 11/28 | APPROVED | BASIC CODES   |  | DESIGN<br>BRADLEY 9/19/10                      |  |
| 4/2/72 | 11/28 | APPROVED | B=MS20410AD<br>BB=MS20426AD   |  | STRESS   |  |
| 4/2/72 | 11/28 | APPROVED | REPORT ALL DISCREPANCIES - DO NOT SCALE   |  | TITLE<br>BRACKET                               |  |
| 4/2/72 | 11/28 | APPROVED |   |  | CODE<br>YU                                     |  |
| 4/2/72 | 11/28 | APPROVED |   |  | DWC NO.<br>D2002-003                           |  |
| 4/2/72 | 11/28 | APPROVED |   |  | SCALE<br>1:2                                   |  |
| 4/2/72 | 11/28 | APPROVED |   |  | SHT<br>1 OF 1                                  |  |
| 4/2/72 | 11/28 | APPROVED |   |  | REV.<br>E                                      |  |

2002

A



|                                 |  |              |         |
|---------------------------------|--|--------------|---------|
| DART AEROSPACE LTD              |  | Work Order:  | 35323   |
| Description: HEATER BRACKET     |  | Part Number: | 2002003 |
| Inspection Dwg: D2002003 Rev: C |  | Page 1 of 1  |         |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø .197            | + .005 - .001 | .197             | x      |        |                      |          |
| 9.350             | +/- .010      | 9.350            | x      |        |                      |          |
| 5.928             | +/- .010      | 5.928            | x      |        |                      |          |
| 7.900             | +/- .010      | 7.900            | x      |        |                      |          |
| 8.812             | +/- .010      | 8.812            | x      |        |                      |          |
| .725              | +/- .010      | .728             | x      |        |                      |          |
| .500              | +/- .010      |                  |        |        |                      |          |
| 1.000             | +/- .010      |                  |        |        |                      |          |
| 2.500             | +/- .010      |                  |        |        |                      |          |
| 4.000             | +/- .010      |                  |        |        |                      |          |
| 4.500             | +/- .010      |                  |        |        |                      |          |
| .269              | +/- .010      | .269             | x      |        |                      |          |
| 2.550             | +/- .010      | 2.550            | x      |        |                      |          |
| 3.493             | +/- .010      | 3.493            | x      |        |                      |          |
| 4.607             | +/- .010      | 4.607            | x      |        |                      |          |
| 5.550             | +/- .010      | 5.552            | x      |        |                      |          |
| .269              | +/- .010      | .269             | x      |        |                      |          |
| .25               | +/- .030      | .25              | x      |        |                      |          |
| 3.063             | +/- .010      | 3.063            | x      |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

|                 |                                |  |
|-----------------|--------------------------------|--|
| Measured by: IB | Audited by: <i>[Signature]</i> | Prototype Approval: <i>[Signature]</i> |
| Date: 07-11-8   | Date: <i>[Signature]</i>       | Date: <i>[Signature]</i>               |

| Rev | Date | Change    | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A   |      | New Issue | KJ/JLM     |          |